

Date: Wednesday, 05/07/2006 2:31:15 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER ASSEMBLY <i>RT</i>
Job Number	: 27837		
Estimate Number	: 10401		
P.O. Number	: <i>N/A</i>	Part Number	: D3163042
This Issue	: 05/07/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3163 REV D
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>N/A</i>
Previous Run	: 27836	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/07/2006 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A05.10.25 New issue KJ/RF Est Rev:06-07-03 As per Rev D JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3163042	Cover Assembly
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Plate REMOVE FROM STK"</p> <p>Qty Part Number Batch 1 D3163-042 <i>B25626</i> (2x) <i>FF</i> 06.07.07 2</p>		
2.0	MS20426AD34	RIVET
<p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>RIVET Batch: <i>M1021</i> <i>MS20426 AD 4-4</i> <i>FF</i> 06.07.07 2</p>		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill / Rivet/COUNTERSINK D3163-041 Touch up c'sink holes with alodine. <i>FF</i> 06.07.07 2</p>		
4.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP Inspect bonding of D3163-1/-3 <i>N/A</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3163042 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.10.05	2	Holes drilled to .128" instead of .098"	<i>[Signature]</i>	USE MS20426 A04H instead of MS20426 A3H	06.10.05 FF	<i>[Signature]</i> 06.10.05	<i>[Signature]</i> 06.10.05	<i>[Signature]</i> 06.10.05

NOTE: Date & initial all entries

Date: Wednesday, 05/07/2006 2:31:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER ASSEMBLY , LH

Job Number: 27837

Part Number: D3163042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

W/A if already printed

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock USING NEW B/N

Location: _____

ST125

PC 4/10/6

(2)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(2)

D 06/10/11

Job Completion

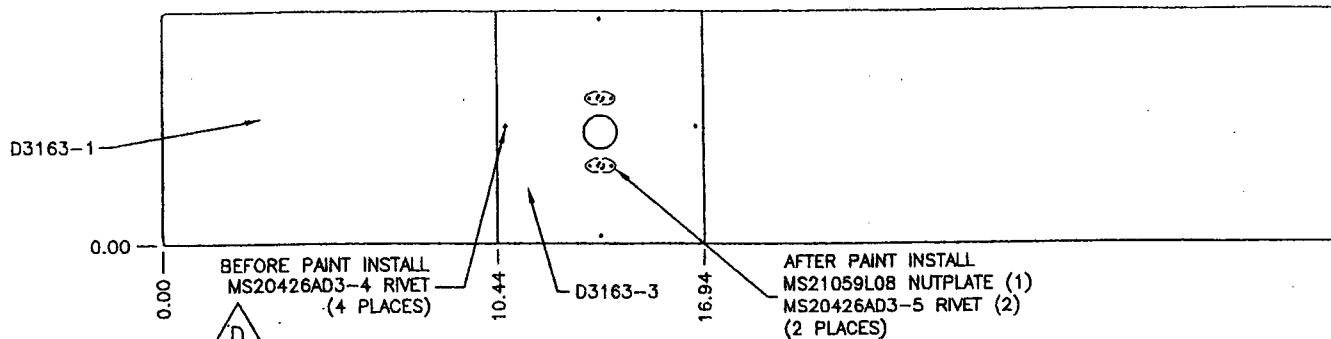


W 06.10.11

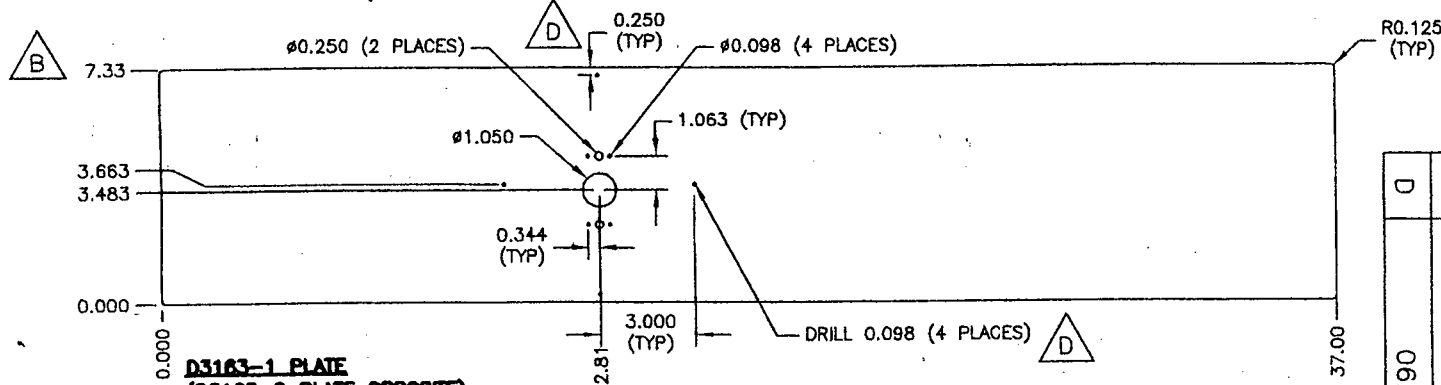
DART

RELEASED
11-06-24-10

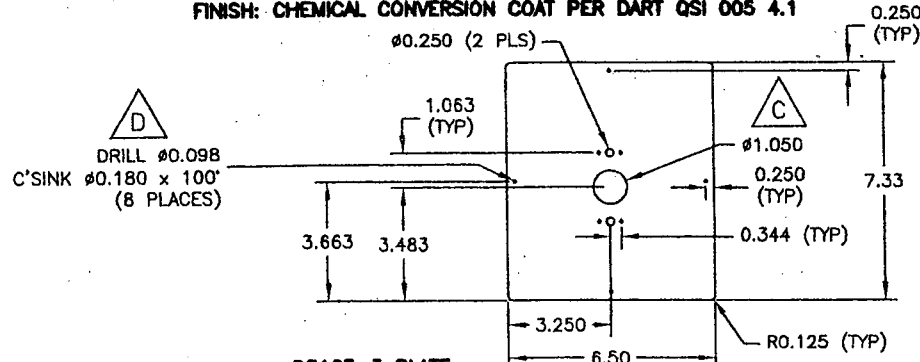
DESIGN	RF	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAMKESBURY, ONTARIO, CANADA
DATE	06.06.26	TITLE	PLATE	REV. 0
		DRAWING NO.	D3163	SHEET 1 OF 1
		SCALE	1:6	
A		02.04.26	NEW ISSUE	
B		04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES	
C		05.11.22	Ø1.050 WAS Ø1.000	
D		06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE	



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)



D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



D3163-3 PLATE
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- GENERAL NOTES:**
- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
 - 2) BREAK SHARP EDGES 0.005 TO 0.010
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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 WORK ORDER
 NO. 22837